

Date: Wednesday, 07/01/2009 1:39:07 PM
 User: Julie Dawson

Process Sheet

SPINT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS STEP RH (FOLDING)
Job Number	: 44489	Part Number	: D412630034
Estimate Number	: 12568	Drawing Number	: IIN D412-630
P.O. Number	:	Project Number	: N/A
This Issue	: 07/01/2009 S.O. No. :	Drawing Revision	: L
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 02/02/2009 Qty: 4 Um: 5 Each
Previous Run	: 44084		
Written By	:		
Checked & Approved By	: <u>JUL 09.01.09</u>		
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUL 09.02.20 ①



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

2.0	D2012107	Clevis
-----	----------	--------



EP 09/02/18

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

B36773 ① B45074 ③

3.0	D2803042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

B41673

EP 09/02/18

4.0	D2804042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

B44551 ② B44492 ②

EP 09/02/18

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Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2807041 Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Support Prop

Batch: B43901

EP09/02/18

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch
B41667

EP09/02/18

7.0 D3562042 Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch
44491

EP09/02/18

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch
B42180

EP09/02/18

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch
M101189

EP09/02/18

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

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Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M109099

09/02/18

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M110023

(12)

09/02/18

M110153 (4)

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

09/02/18

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M104251

09/02/18 (4)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/18 (4)

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	42174

SS 09/02/17 (X)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	42175

SS 09/02/17 (X)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	41676

SS 09/02/17 (X)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	B41676

SS 09/02/17 (X)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
			M109147

SS 09/02/17 (X)

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Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M104679

SS 09/02/17 (X)

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M107082

SS 09/02/17 (X)

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M100446

SS 09/02/17 (X)

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M105125

SS 09/02/17 (X)

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M109267

SS 09/02/17 (X)

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: ³21.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M109430

SS 09/02/17 (X)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: ⁴12.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M16023

SS 09/02/17 (X)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: ³9.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M16123

SS 09/02/17 (X)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

For 2017

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

Rev A

SS 09/03/13 (X)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/16

Job Completion



09.03.16

D412-630-033/-034 Heli-Access-Step™ Installation

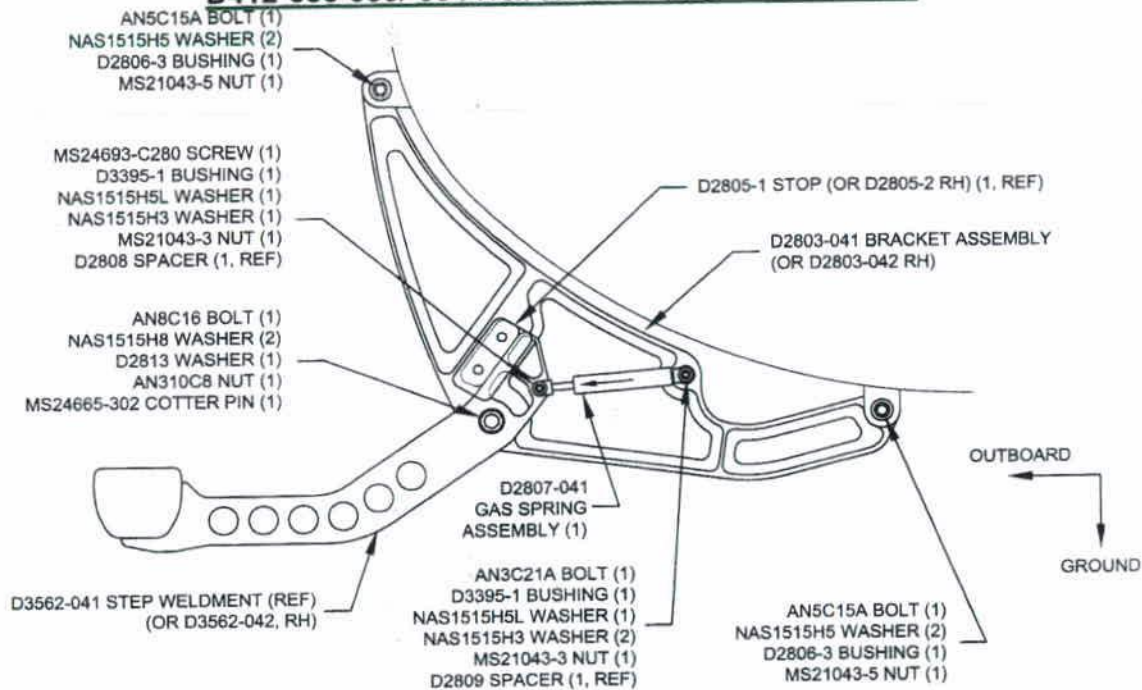


FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)

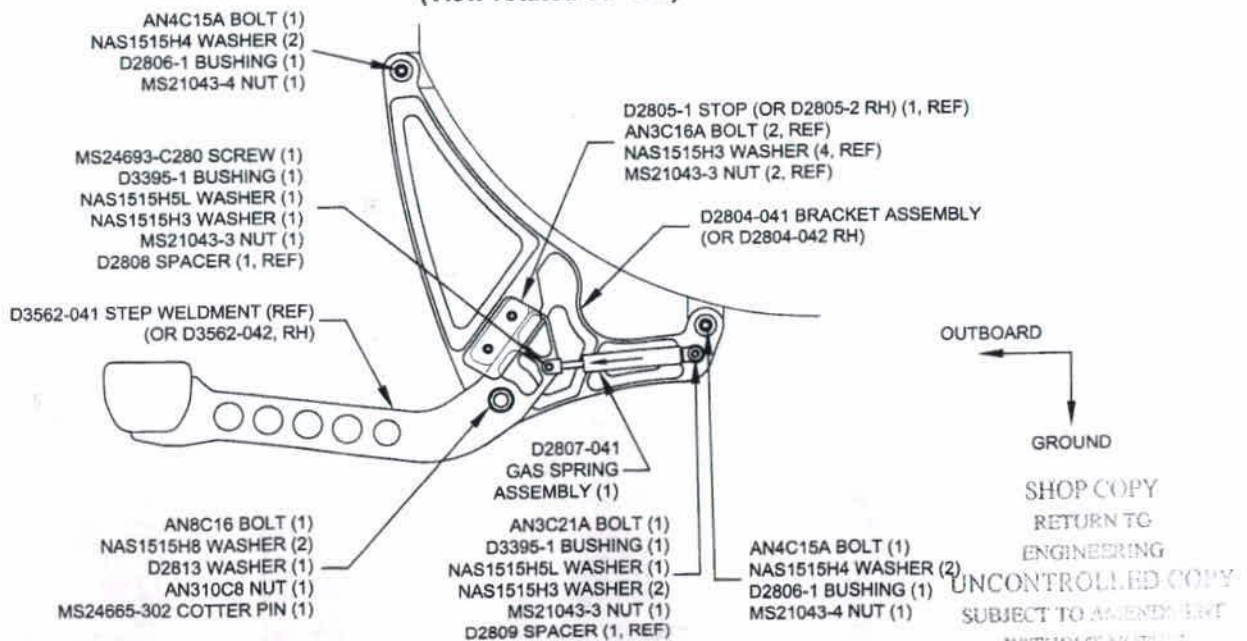


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)

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Revision: L
Date: 07.09.30

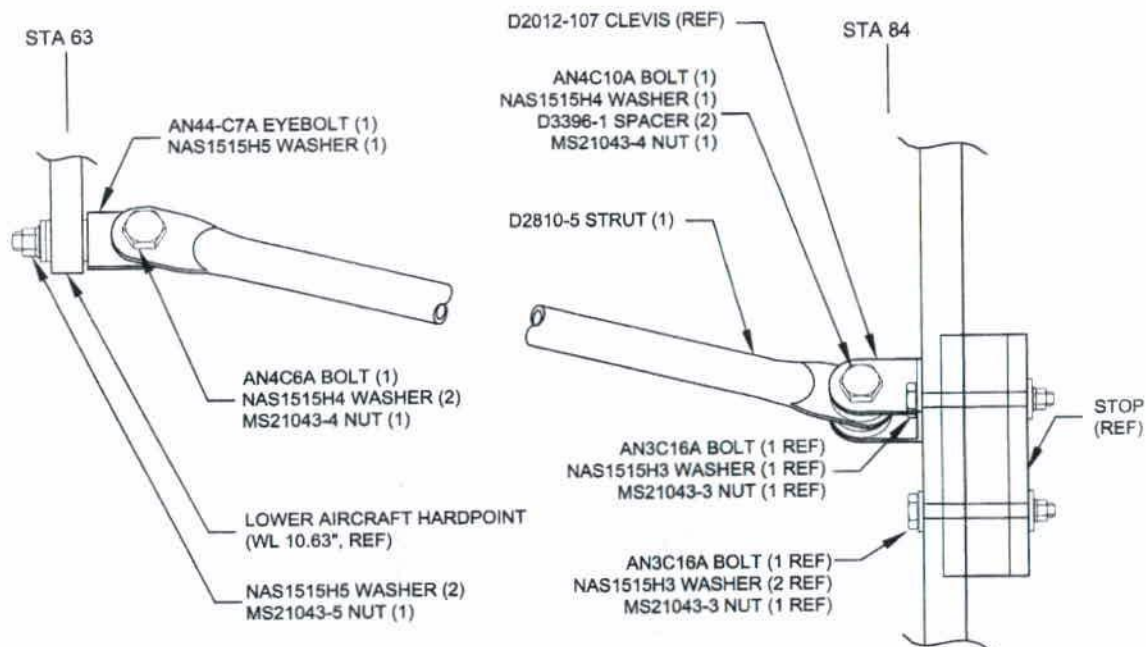


FIGURE 16 – Strut Detail for D412-630-033/-034 Heli-Access-Step™ Installation
(NOT TO SCALE)

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Revision: L
Date: 07.09.30